Tuesday, June 21, 2011 10:35:42 AM





Page 1

Item ID: **Revision ID: Item Name: Start Date:**

D3293-1

Accept



Setup Start



Doubler

Required Date: 6/27/2011

6/21/2011

Start Qty: 12.00

Req'd Qty: 12.00

Cust Item ID: Customer:

Reference:

Approvals:	

Process Plan:

Date://///

Tooling:

Date:

Run

Start

Stop



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID Operation Description

Revision Nbr

Set Up/ Run Hours Tool ID

Tool # Plan Code

Accept Oty

Reject Otv

Reject Insp. Number Stamp

Draw Nbr D3293

Rev A

100

FLOW WATER JET

Waterjet

0.00

0.00

B11-7-4

FLOW CNC Waterjet

UPD. HCGG.

Memo

1-Cut as per Dwg D3293 Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

□Dwg Rev:

□Prog Rev:

110

Memo

0.00

B11-7-4

Quality Control

0.00

120

Quality Control

QC8- Inspect parts - second check

Memo

Dart Aerospace Ltd

Dail Ac	Ospace								•
W/O:			W	ORK ORDER CHANGE	ES			***************************************	
DATE	STEP	PROC	EDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								·	
Part No	•	PAR #:	_ Fault Cate	egory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	_ Disposition	on:	QA: N/C CI	osed:		Date: _	
NCR:		We	ORK ORD	ER NON-CONFORMA	NCE (NCF)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	n B Sign & Date	- Verific Section		Approval Chief Eng	Approval QC Inspector
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							<u> </u>		
				No.					

Tuesday, June 21, 2011 10:35:42 AM



Page 2

Item ID:

D3293-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Doubler

Required Date: 6/27/2011

6/21/2011

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID: Customer:

Tool ID

Reference:

An	prova	ale:
A.D	$D1 U V \epsilon$	113.

Process Plan: _____

QC: __

Date:

Tooling:

Date:

Run

Accept

Qty

Start



Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool # Plan

Code

Stop

Reject

Qty



Number Stamp

Insp.

Reject

Sequence ID/ **Work Center ID**

130



Small Fab

Small Fab

140

Quality Control

Operation Description

Small Fab

Memo

1- Deburr

QC5- Inspect part completeness to step on W/O

Memo

0.00

Chemical Conversion Coat per OSI005 4.1

0.00

HandFinish

Hand Finishing

1.50

Memo

0.00

12X & M-fulo7/05

Dart Aerospace Ltd	D	art	Aer	ospa	ice	Ltd
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W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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								,			
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:			
	R	esolution:	Dispositio	1:	_ QA: N/C C	losed:		Date: _			
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCI	R)			:		
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B Sign		cation	Approval	Approval		
		Section A	Chief Eng	Chief Eng	Date		ion C	Chief Eng	QC Inspector		
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Tuesday, June 21, 2011 10:35:42 AM



Page 3

Item ID:

D3293-1

Date:

Tool # Plan

Code

Setup Start



Revision ID:

Start Date:

Item Name:

Required Date: 6/27/2011

Doubler

6/21/2011

QC:

Start Qty: 12.00 Req'd Qty: 12.00

Date:_____

Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Set Up/

0.00

Run Hours

Accept

Date:

Run

Accept

Qty

Start

Stop

Reject

Stop

Reject

Qty

Number Stamp

Insp.

Sequence ID/

Work Center ID

Powdercoat

160

Powder Coating

170

Quality Control

Operation Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Memo

□OVEN TEMPERATURE:

☐FINISH TIME:

QC3- Inspect Part Finish

Memo

0.00

0.00

12 d My 103/03

180

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

Packaging

0.00

Dart Ae	rospace L	td							
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	Jory:	NCR: Ye	es No	DQA:	Date: _	
	Res	olution:	Disposition	:	_ QA: N/C	Closed	l:	Date: _	
NCR:		· · · · · · · · · · · · · · · · · · ·	WORK ORDE	R NON-CONFORM	ANCE (N	CR)			•
		Description of NC Corrective Actio		Corrective Action Sect	on B	V	erification	Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & vate	Section C	Chief Eng	QC Inspecto
2							;		

Page 4

Tuesday, June 21, 2011 10:35:42 AM

Item ID:

D3293-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Doubler

Start Date: 6/21/2011

Required Date: 6/27/2011

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date: _____

Date: Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Start

Run



Sequence ID/ **Work Center ID**

QC

Quality Control

Operation Description

QC21- Final Inspection - Work Order Release

0.00 11:

0.00

Tool ID

Date:

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Memo

DATE ST	TEP	PRO	OCEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	1								
Part No: _		PAR #:	Fault Categ	gory:	NCR: Yes	No DQA:		Date:	
	Resol	ution:	Disposition):	QA: N/C C	losed:		_ Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMAN	CE (NC	R)			·
DATE S	TEP	Description of NC		Corrective Action Section B		Verifica	tion	Approval	Approval
DATE 5	OIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section		Chief Eng	QC Inspecto
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Picklist Print

Tuesday, June 21, 2011 10:35:48 AM

Work Order ID: 71029

Parent Item:

D3293-1

Parent Item Name: Doubler



Start Date: 6/21/2011

Required Date: 6/27/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP: □A□04.08.24□New issue□KJ/JLM□ IPP Rev:B Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080	1111 111 (1 218 111 8 118 1 (8111 8 411)	Purchased	No			100	sf	110.1000	1.8264	23.07032	2		
										B11-	7-4		

2024-T3 .080 sheet

<u>Location</u>	Loc Qty	Loc Code	
MAT022	110.1		
105411	6		
109424	4		
110347	0.5		
110908	3		
112331	3		
113796	7		
114025	17.2	•	
116604	5.8		
117392	63.6		118180
118180			

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W/O:			WO	RK ORDER CHANGES	S		A	T
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
· —-								
Part No):	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA:	Date: _	
•	Resc	olution:	Disposition	:	QA: N/C C	osed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMAN	ICE (NCF	₹)		
DATE	OTED	Description of NC	Corrective Action Section B			Verification	1 Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8	Section C	Chief Eng	QC Inspecto
							į.	1
		·						

DART AEROSPACE LTD

Work Order: 344

Description: Doubler

Part Number: D3293-1

Inspection Dwg: D3293 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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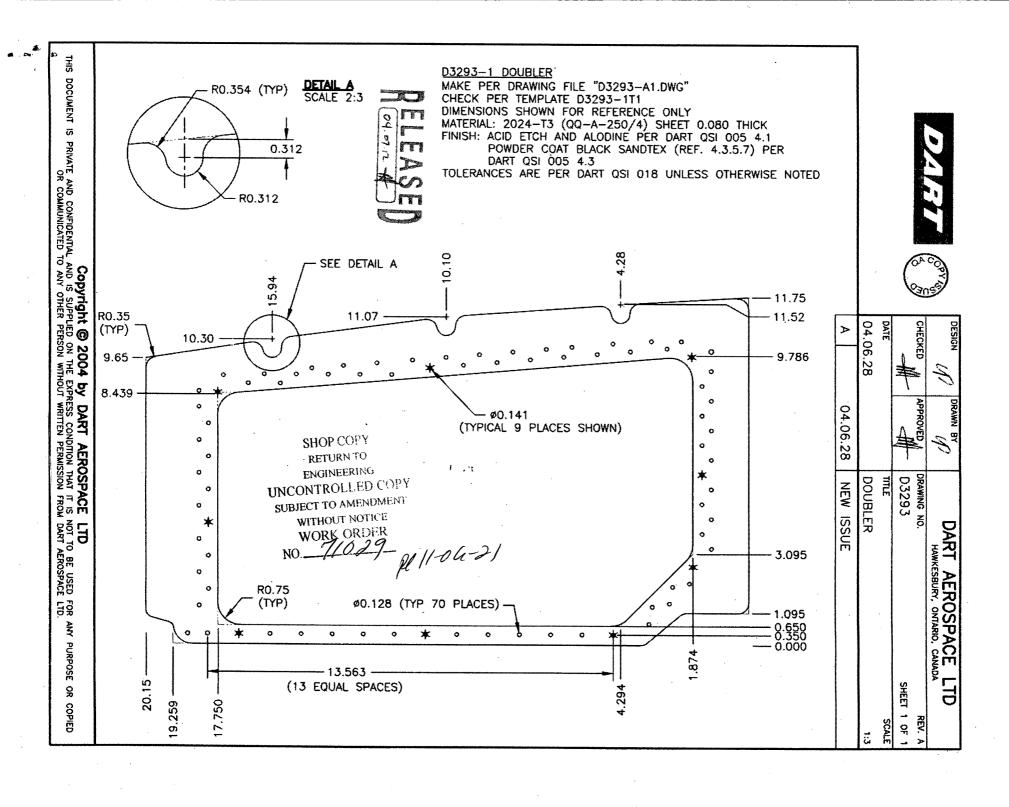
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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1.874	+/-0.010	1.876	8		V	
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Ø0.128	+0.005/-0.001	1139	>		V	
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Measured by: 🖟	Audited by:	Prototype Approval:	N/A
Date: 11-7-4	Date: 1107/05	Date:	N/A

Rev	Date	Change ,	Revised by	Approved
Α	04.08.24	New Issue	KJ/JLM 1.A	
В	08.10.09	0.080 dimension added	KJ/DD	<i>X</i>

Dart Aer	rospace	∍ Ltd							
W/O:			WC	ORK ORDER CHANGES	;				
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory: ħ	ICR: Yes	No DQ	 }A:	Date: _	1
	R	lesolution:	Disposition	n: (A: N/C CI	osed:	Brown and a second	Date: _	
NCR:		V	VORK ORDE	ER NON-CONFORMANO	CE (NCF	})			
DATE	STEP	Description of NC Section A	Initial Action Description		Sign 8	& Sect	ication tion C	Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng	Date				
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NOTE: Date & initial all entries



W/O:			WO	RK ORDER CHAN	GES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:								
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DATE	CTED	Description of NC			ction B		Verific	cation	Approval	Approval
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Se Action Description Chief Eng		Sign & Date		cation ion C	Approval Chief Eng	
DATE	STEP	Description of NC Section A	Initial	Action Description						Approval QC Inspecto
DATE	STEP	Description of NC Section A	Initial	Action Description						
DATE	STEP	Description of NC Section A	Initial	Action Description						